

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007054**Date Inspected:** 04-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2130**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Makhmud Ashadi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:**

On this date, 6/04/09, Caltrans OSM Quality Assurance Inspector (QAI) Mike Brcic was present during the times noted above for observations relative to the work being performed on cast sections and their associated built up plate sections in the Fabrication shop #4 and Foundry at Japan Steel Works (JSW), Muroran, Hokkaido, Japan.

WEST DEVIATION SADDLES

W2E2 - Saddle Section is idle in Fabrication shop #4, QA Inspector and SMR Jay Dorst met with JSW personnel, Mr. Sato and Mr. Kon to discuss mismatch at rib 2-13 to cast rib exceeding tolerance, Mr. Sato acknowledged the nonconformity and need for resolution. Therefore it will be logged as a Blue Tag item.

W2E3 - While awaiting disposition of repair of joint E3S-2U, saddle section has been forwarded on to No.4 Machine Shop for final machining.

W2W2 - Saddle Cast section has had locations identified for stay bars spanning the trough, buttered. Per QC Mr Chung Fu Kuan, the locations for lifting lugs on ends will be beginning in a day or so, in Fabrication Shop #4.

W2W3 - Saddle Casting is idle in Foundry. Built up Plate portion is being joint welded by M. Matudate 08-5151, T. Watanabe 08-5153, S. Watanabe 08-5159 welding joints W3Y-4L-2, W3Y-7V, W3Y-8V respectively. Method employed is FCAW TM95 1.6mm consumable wire utilizing procedure SJ-3011-2 and -3 parameters were periodically checked by CWI QC Inspector Mr. Chung Fu Kuan. QA Inspector accompanied QC CWI, Mr. Makhmud Ashadi as he performed his duties verifying parameters of procedure SJ-3011-2 on "B" shift welders Y. Maeyama 94-5234, T. Inoue 08-5163, M. Kashiwada 08-2008 as they continue welding joints W3Y-17L, W3Y-6L and W3Y-5L using FCAW, TM95 in the 1G position.

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TOWER SADDLES

T1-2 - JSW personnel were actively erecting staging around newly relocated saddle, "A" shift CWI, Mr. Chung Fu Kuan, informed QA Inspector no welding would take place due to need for preheat temperatures be met.

T1-3 - Saddle structure (minus its base plate) has been sent for Intermediate Stress Relief (ISR).

EAST DEVIATION SADDLES

E2E1 - Saddle casting is having excavations, on ID'd side of the casting, grinding of MT'd and PT'd indications is being conducted in the Foundry.

E2W1 - While located in the Foundry, casting is awaiting ECS to begin weld repairs. In Fabrication Shop #4, Bearing plate is idle at this time.

Splay Plate covers for E2E1/E2W1, plates 24-4 (one each), are having their backing bar rooted by welder M. Yamashita 73-4195 using SMAW 4mm E7016 and done per procedure SJ-3177-1. CWI QC Inspector Mr. Makhmud Ashadi is randomly verifying parameters with calibrated instruments.

West Jacking Saddle has one JSW personnel actively shaping by way of Carbon Arc in Foundry.

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

Summary of Conversations:

No significant conversations to report on this day.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Brcic,Michael	Quality Assurance Inspector
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Reviewed By:	Peterson,Art	QA Reviewer
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